

September 02, 2015 11:24:50 AM

Page 1

1509-23

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coor. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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OTHER : _____																																																																					

Work Order ID 136324

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136324

Page 2

Item ID: D4895-045 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Fwd Outboard Beam Assembly
Start Date: 9/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/9/2015 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				1	0		DAS 20 9-89 15-09-23
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				1	0		DAS 14 9-89 15-09-23
160 *160* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				1	0		15-9-23 DGE

DQA: _____ Date: _____

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QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
☐ OTHER : _____					

Work Order ID 136324

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136324

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Item ID: D4895-045 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fwd Outboard Beam Assembly
 Start Date: 9/2/2015 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 9/9/2015 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	QC7-Inspect Chemical Conversion Coat	0.00				1	0	15-9-23	DAS 34 9-89
170									
QC	Memo	0.00							
Quality Control									
171	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00				1	0	15-9-23	DAS 34 9-89
171									
Powdercoat	Memo	0.00							
Powder Coating	MASK HOLES AS PER NOTE 8								
	START TIME: 1:40								
	OVEN TEMPERATURE: 320°								
	FINISH TIME: 2:10								
172	QC3- Inspect Part Finish	0.00				1			DAS 38 9-89
172									
QC	Memo	0.00							
Quality Control									

SEP 24 2015

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Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
☐ OTHER : _____					

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180									
Small Fab	Memo	0.00				<u>1</u>	<u>FF</u>	<u>SEP 24 2015</u>	
Small Fab	PRESS FIT BUSHING AS PER DWG								
190		0.00							
190									
QC	Memo	0.00				<u>/</u>			
Quality Control									DAS 38 9-89 <u>SEP 24 2015</u>
200		0.00							
200									
Packaging	Memo	0.00							
Packaging	Identify as per dwg & Stock Location: _____ PPP 136321								DAS 27 9-89 <u>SEP 24 2015</u>

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :				MRB (QS1042) Approval	
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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Item ID: D4895-045

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Fwd Outboard Beam Assembly

Stop *NS2*

Start Date: 9/2/2015 **Start Qty:** 1.00

*** 1 ***

Cust Item ID:

Required Date: 9/9/2015 **Req'd Qty:** 1.00

*** 1 ***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation Description

Set Up/ Run Hours

Tool ID**Tool #****Plan
Code**

**Accept
Qty**

Reject
QtyReject
Number

**Insp.
Stamp**

210

QC21- Final Inspection - Work Order Release

0.00

210

QC

Memo

0.00

Quality Control

20150925

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :			MRB (QSI042) Approval
Description Work Order Deviation		Disposition			Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Picklist Print

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Work Order ID: 136324

136324

Parent Item: D4895-045

D4895-045

Parent Item Name: Fwd Outboard Beam Assembly

Start Date: 9/2/2015

Required Date: 9/9/2015

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4859-1		Manufactured	No				Each	6.0000		4			
D4859-1									**			SEP 24 2015	
Bushing													

Location	Loc Qty	Loc Code
ST132	6	
122987	4	
124826	2	

M6061T6B1.000X12.00
0

Purchased No

f 17.0500

3.168421

M6061T6B1 000X12 000

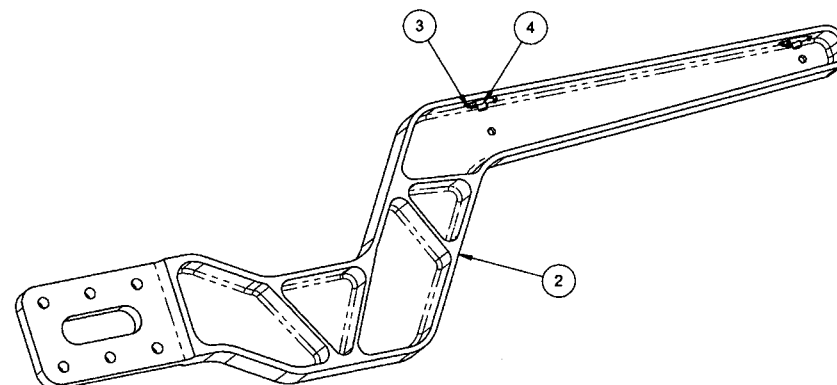
6061-T6 Bar 1.00 x 12.00

Location	Loc Qty	Loc Code
MAT007	17.05	
m115844	3.467	
M126351	1.5	
m130013	1	
m130527	11.083	

3.467

09/15/09/03

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4895-041	FWD OUTBOARD BEAM ASSY
2	1	D4895-1	FWD OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



D4895-041 FWD OUTBOARD BEAM ASSY

NOTES:
 1) MATERIAL: N/A
 2) FINISH: N/A
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 7) WEIGHT: 3.31 lbs

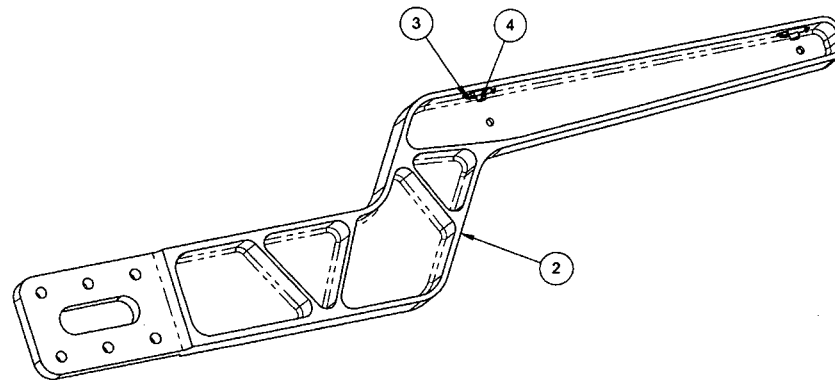
RELEASED
 2014-07-24

20150902 SH 136324

B	ADD D4895-5/-7/-045/-047 (ZN A4-3, A4-4, A4-7, A4-8), ADD NOTE 9 (ZN A8-5, A8-6, A8-7, A8-8)	RF	14.04.11
A	NEW ISSUE	RF	13.05.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4895	SHEET 1 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
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APPROVED

ITEM	QTY -043	P/N	DESCRIPTION
1	X	D4895-043	AFT OUTBOARD BEAM ASSY
2	1	D4895-3	AFT OUTBOARD BEAM
3	4	MS20426AD3-(5)	RIVET
4	2	MS21059-4	NUT PLATE



D4895-043 AFT OUTBOARD BEAM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.25 lbs

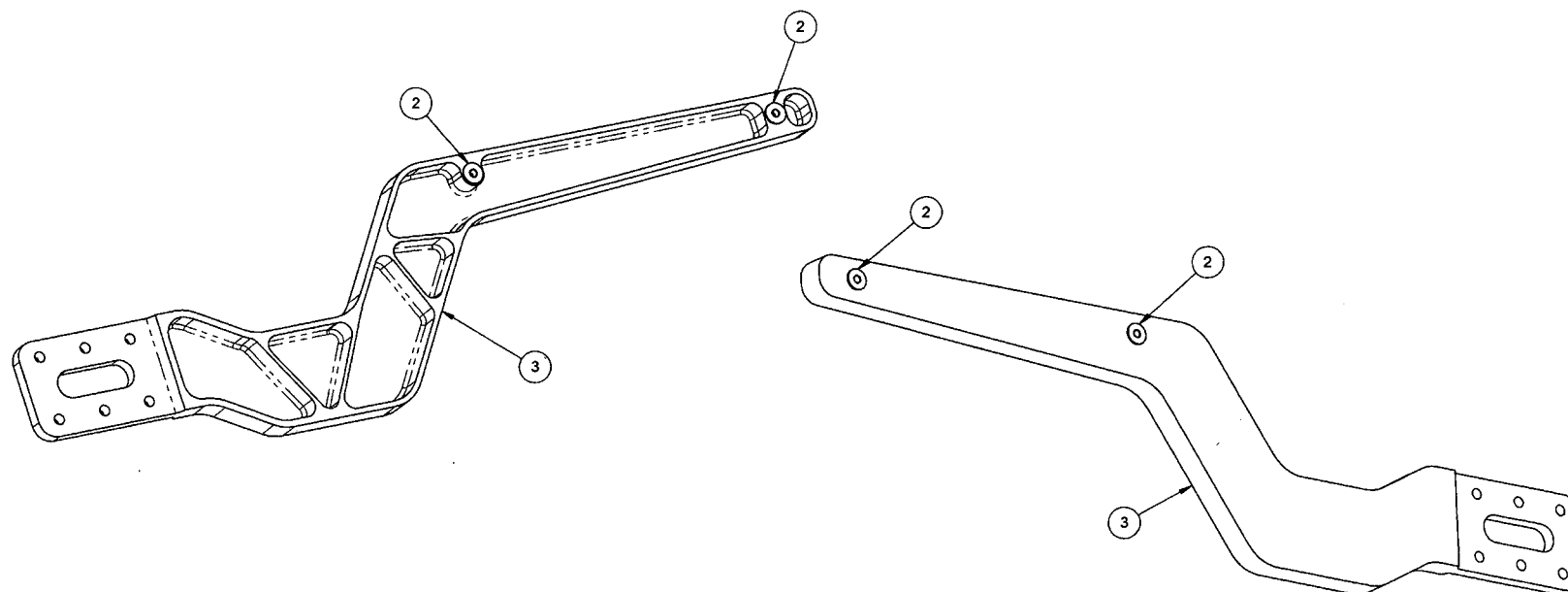
APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4895	REV. B
MFG. APPR.	JLM	TITLE OUTBOARD BEAM	SHEET 2 OF 9
APPROVED	HS	SCALE NTS	
DE APPR.	DS	DATE 14.04.11	

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2014-07-24
mp

ITEM	QTY -045	P/N	DESCRIPTION
1	X	D4895-045	FWD OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-5	FWD OUTBOARD BEAM



D4895-045 FWD OUTBOARD BEAM ASSY

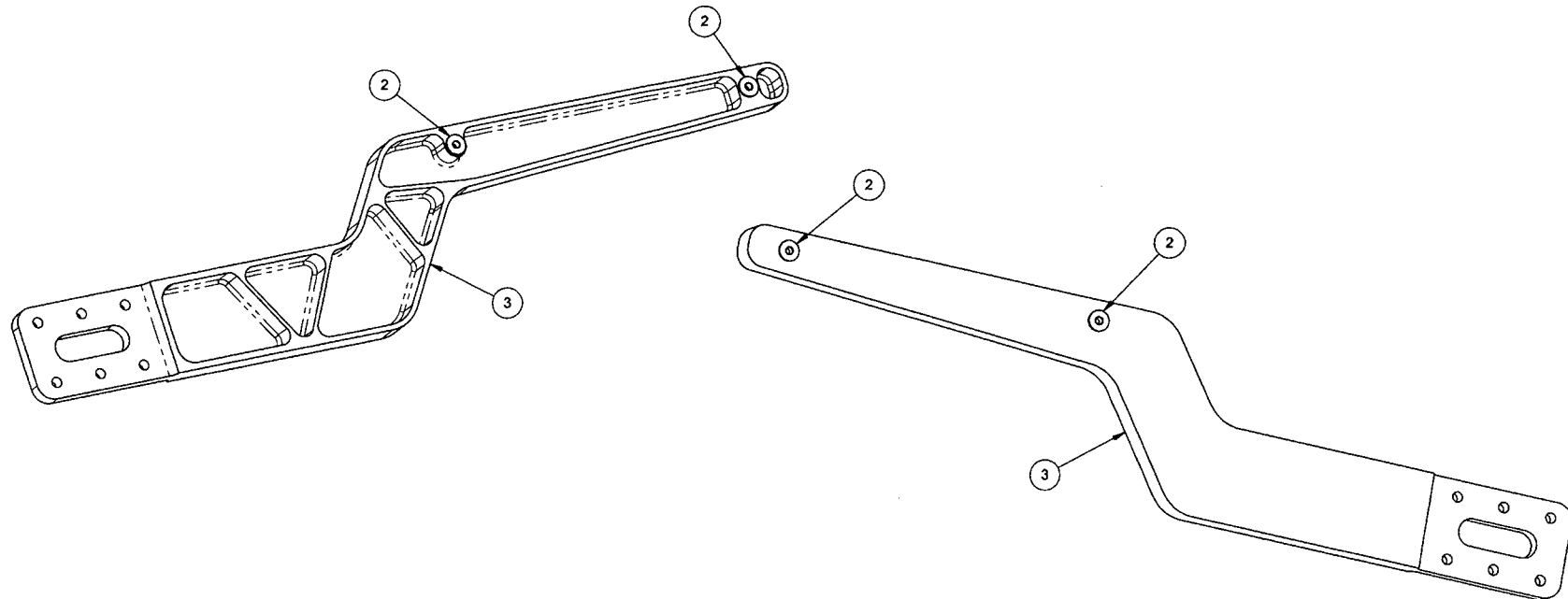
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.50 lbs
- 8) PRESS FIT D4859-1 INTO D4895-5. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

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2014-07-24

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 3 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
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ITEM	QTY -047	P/N	DESCRIPTION
1	X	D4895-047	AFT OUTBOARD BEAM ASSY
2	4	D4859-1	BUSHING
3	1	D4895-7	AFT OUTBOARD BEAM



D4895-047 AFT OUTBOARD BEAM ASSY B

NOTES:

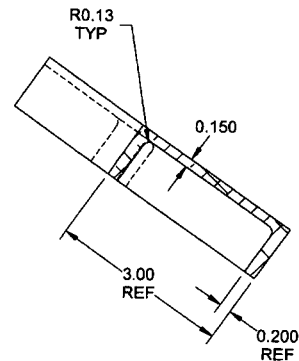
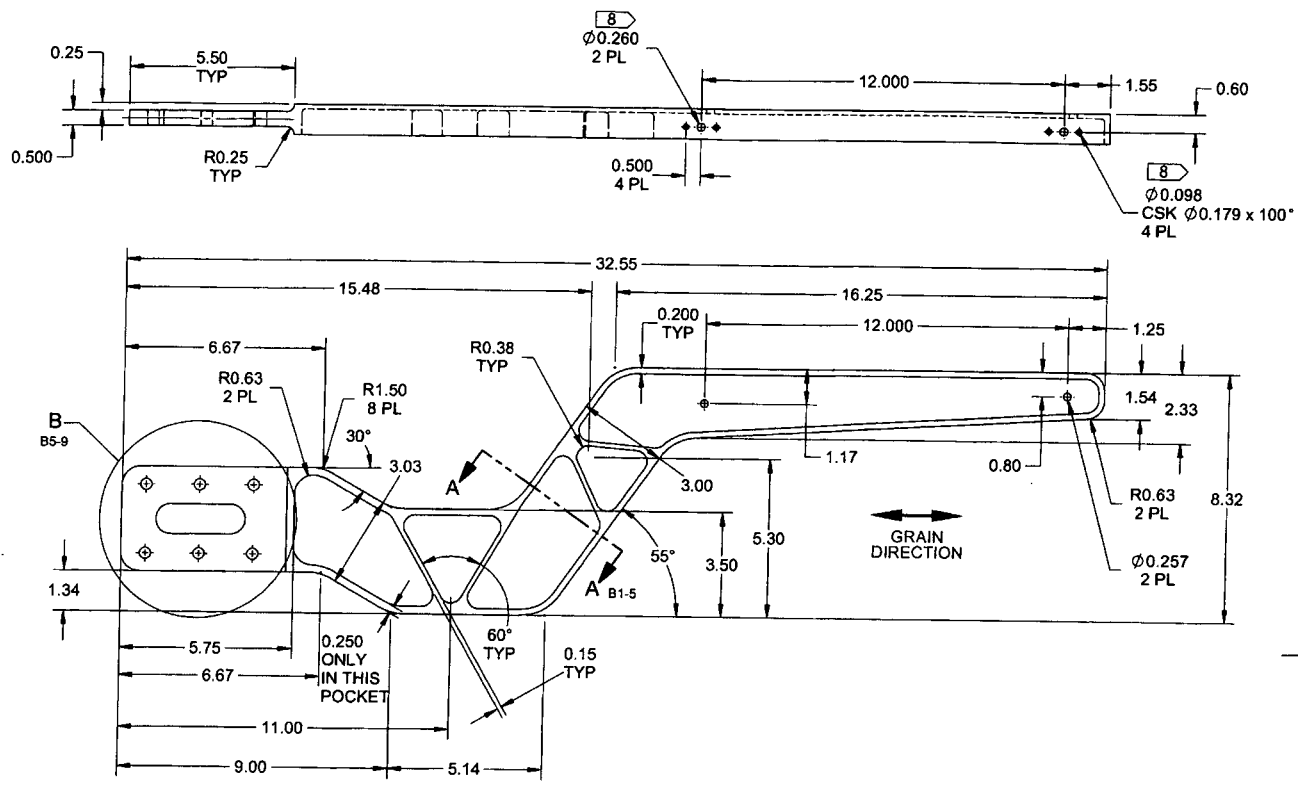
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 3.44 lbs
- 8) PRESS FIT D4859-1 INTO D4895-7. IT IS ACCEPTABLE USE MAGNABOND ADHESIVE, REMOVE EXCESS ADHESIVE FROM BUSHING HOLE

RELEASED
2014-07-24
WJ

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4895	REV. B
MFG. APPR.	JLM	TITLE OUTBOARD BEAM	
APPROVED	HS		
DE APPR.	DS	SCALE NTS	
DATE	14.04.11		

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D4895-1 FWD OUTBOARD BEAM

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2014-07-24

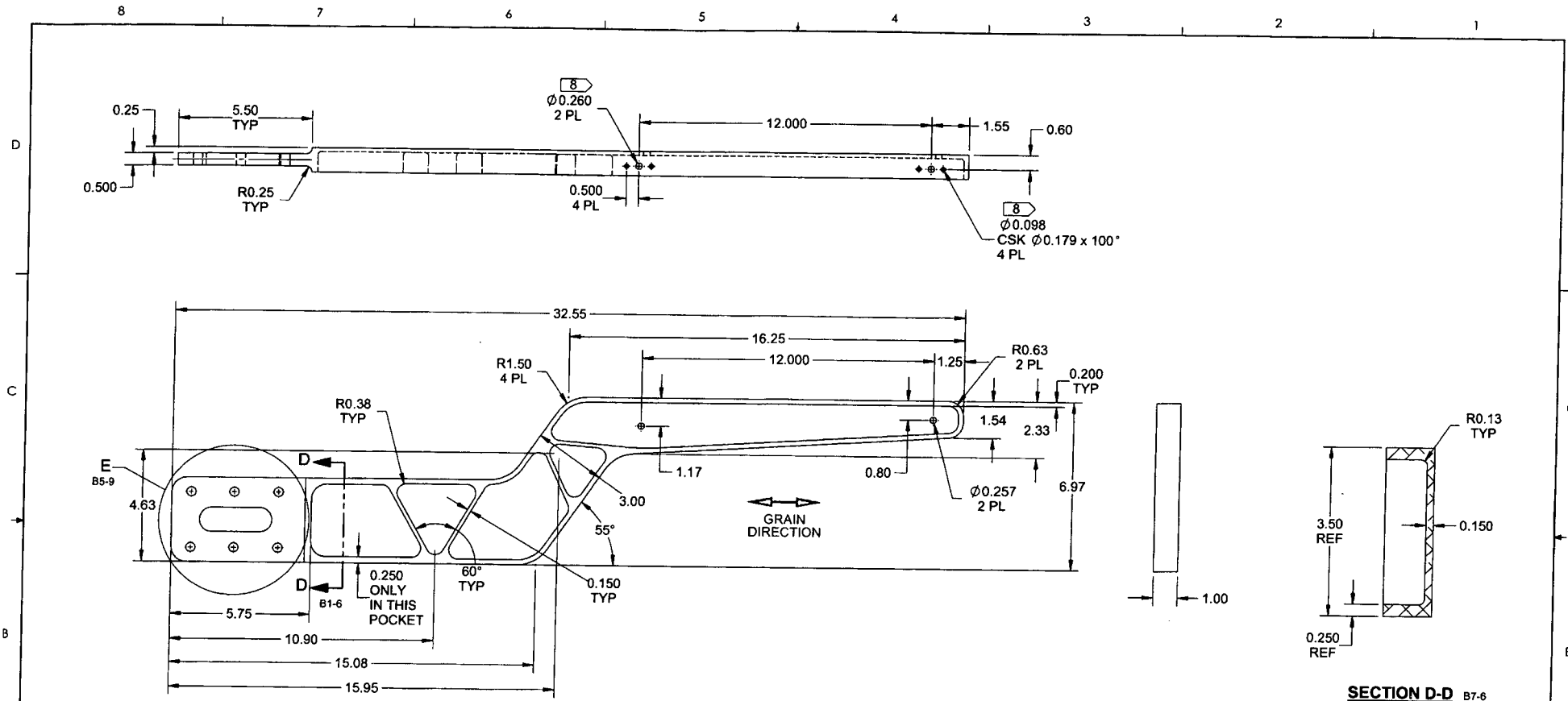
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.30 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-1.SLDPRT

APPROVED

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO. D4895	REV. B
MFG. APPR.	JLM	SHEET 5 OF 9	
APPROVED	HS	TITLE	
DE APPR.	DS	OUTBOARD BEAM	
DATE	14.04.11	SCALE NTS	

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D4895-3 AFT OUTBOARD BEAM

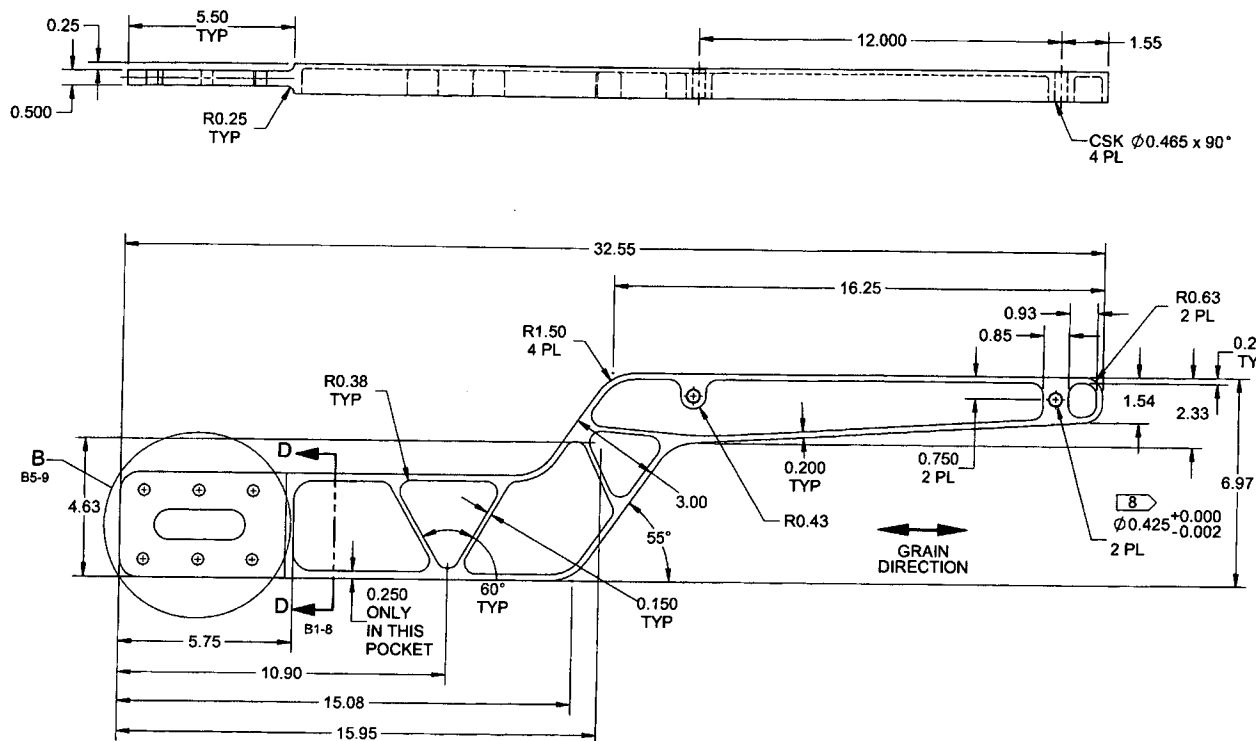
NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.25 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-3.SLDPRT

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2014-07-24

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DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	VS	DRAWING NO.	REV. B
MFG. APPR.	JLM	D4895	SHEET 6 OF 9
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	OUTBOARD BEAM	NTS
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SECTION D-D B7-8

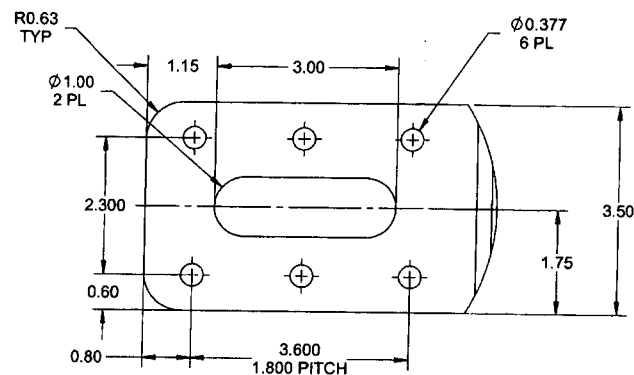
D4895-7 AFT OUTBOARD BEAM

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 3.39 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT
- 9) UNDEFINED FEATURES CONTROLLED BY CAD FILE D4895-7.SLDPRT

RELEASED
2014-07-24

APPROVED	DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 8 OF 9
	APPROVED	HS	TITLE	SCALE
	DE APPR.	DS	OUTBOARD BEAM	NTS
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DETAIL B
C8-5
C8-6
C8-7
C8-8

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	DRAWN	RF		
	CHECKED	VS	DRAWING NO.	REV. B
	MFG. APPR.	JLM	D4895	SHEET 9 OF 9
	DE APPR.	DS	TITLE	SCALE
	DATE	14.04.11	OUTBOARD BEAM	NTS
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DART AEROSPACE LTD		Work Order:	136324
Description: Fwd Outboard Beam		Part Number:	D4895-5
Inspection Dwg: D4895	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓	SLOI	Tape
	R0.38	+/-0.030	.380	✓	Rad gauge	
	0.85	+/-0.030	.858	✓	SLO8	Vern
	0.93	+/-0.030	.910	✓		
	8.32	+/-0.030	8.320	✓		
	Ø0.425	+0.000/-0.002	.424	✓	gauge	PIN
	0.750	+/-0.010	.750	✓		
	0.200	+/-0.010	.198	✓		
	R0.43	+/-0.030	.430	✓	Rad gauge	
	3.00	+/-0.030	3.000	✓		
	3.50	+/-0.030	3.500	✓		
	0.15	+/-0.030	.149	✓		
	0.250	+/-0.010	.250	✓		
	5.75	+/-0.030	5.750	✓		
	1.34	+/-0.030	1.340	✓		
	1.00	+/-0.030	1.005	✓		
	R0.13	+/-0.030	.125	✓	Rad gauge	
	0.150	+/-0.010	.151	✓		
	1.15	+/-0.030	1.150	✓		
	3.00	+/-0.030	3.000	✓		
	Ø0.377	+0.006/-0.001	.377	✓	gauge	PIN
	3.50	+/-0.030	3.500	✓		
	1.75	+/-0.030	1.750	✓		
	3.600	+/-0.005	3.600	✓		
	1.800	+/-0.005	1.800	✓		
	0.80	+/-0.030	.798	✓		
	0.60	+/-0.030	.598	✓		
	2.300	+/-0.005	2.300	✓		
	Ø1.00	+/-0.030	1.000	✓		
Manual Mill	0.25	+/-0.030	.255	✓		
	5.50	+/-0.030	5.505	✓		
	12.000	+/-0.005	12.000	✓		
	1.55	+/-0.030	1.547	✓		
	Ø0.465 X 90°	+/-0.010 x 0.5°	.465 X 90°	✓		
	R0.25	+/-0.030	.250	✓	Rad gauge	
	0.500	+/-0.010	.501	✓	SLO8	

Measured by:	DAS 20 9-89
Date:	15-09-23

Audited by:	DAS 14 9-89
Date:	15/09/23

Preliminary Approval:	
Date:	

Rev	Date	Change	Revised by	Approved
A	14.08.05	New Issue	KJ	